

Dep Friday 28/05

Work Order ID 59129

May 26, 2010 1:32:41 PM



Page 1

Item ID: D3372-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Collective Lock Assembly

Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372 Identify as D3372-3

=> m.l 10/05/27

(IX)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/05/27

(IX)

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

=> m.l 10/05/27

(IX)

May 26, 2010 1:32:42 PM



Accept

**Setup Start**

Revision ID:

Stop



Item Name: Collective Lock Assembly

Start Date: 5/26/10 **Start Qty:** 1.00

**Cust Item ID:**

Required Date: 5/28/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____

Dates:

**Insp.
Stamp**

0.00



Small Fab

0.00

Small Fab

Memo

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty	Part Number	Description	Batch
A/R	N/A	Locktite 262	M

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

0.00



Large Fab

0.00

Large Fab

Memo

Tack weld lock shaft as per Dwg D3372

A/R SS Rod Batch 111679

Large Fab

Work Order ID 59129

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Page 4

Item ID: D3372-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Collective Lock Assembly

Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10
MF
10-5-27

Picklist Print

May 26, 2010 1:32:39 PM

Page 1

Work Order ID: 59129

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 5/26/10

Required Date: 5/28/10

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
IPP Rev:B Added Key ID _____ 06.03.21 EC
added D3384-043 DD 10.05.13 verified :EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
5/16WC		Purchased	No			100	Each	349.0000	2	2			



SS Flat Washer 5/16

Location

Loc Qty

Loc Code

ST377

349

112560

249

114758

100

AN5-42A

Purchased

No

100

Each

46.0000

1

1



Bolt

Location

Loc Qty

Loc Code

ST341

46

108442

46

AN960-416

NAS1149F0463P

Purchased

No

100

Each

0.0000

2

2



Washer

D2728-7

Manufactured

No

100

Each

0.0000

0

0



Dart Logo label

D3372-1

Manufactured

No

100

Each

1.0000

1

1



Main Body

Location

Loc Qty

Loc Code

ST485

1

58444

1

SB 10/05/27

2

SB 10/05/27

1

SB 10/05/27

2

SB 10/05/27

1

SB 10/05/27

1

Picklist Print

May 26, 2010 1:32:39 PM

Page 2

Work Order ID: 59129

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly






Start Date: 5/26/10

Required Date: 5/28/10

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
IPP Rev:B Added Key ID 06.03.21 EC
added D3384-043 DD 10.05.13 verified :EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3372-5		Manufactured	No			100	Each	5.0000	1	1			
													
Cam Lock Shaft													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST052			5					
					58654			5					
D3372-7		Manufactured	No			100	Each	2.0000	1	1			
													
Slider Body													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST485			2					
					58439			2					
D3373-1		Manufactured	No			100	Each	41.0000	1	1			
													
Cam Lock													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST052			41					
					44105			2					
					58463			39					
D3384-041		Manufactured	No			100	Each	0.0000	1	1			
													
Cyclic Sock Assembly													
HX-81		Purchased	No			100	Each	48.0000	1	1			
													
1/4"-20 SHCS 3/8" long													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST390			48					
					114383			48					

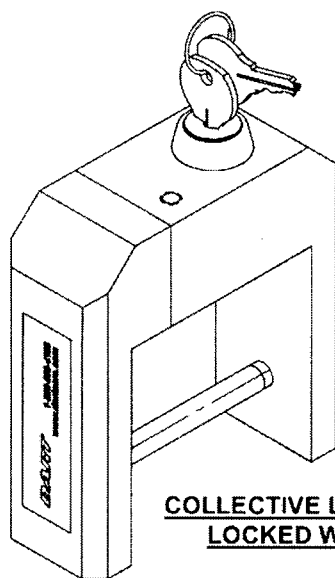
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Shop Packet Print

Page 2

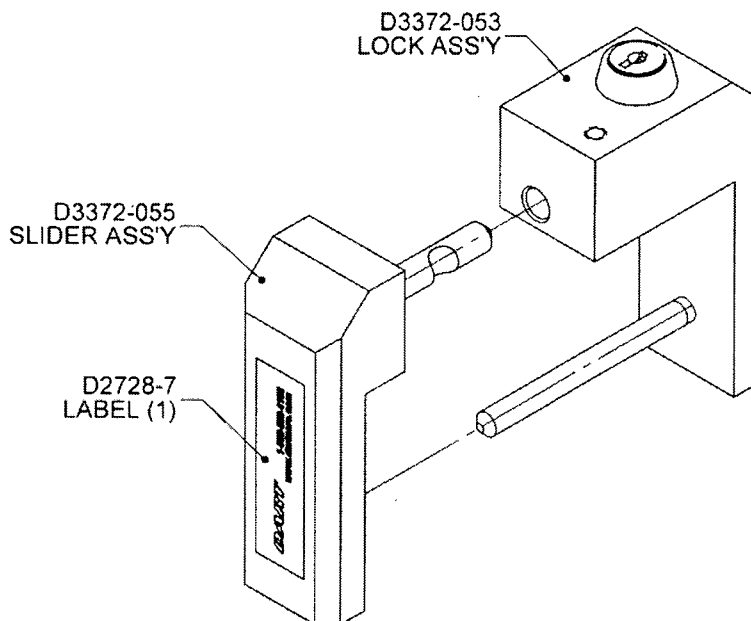
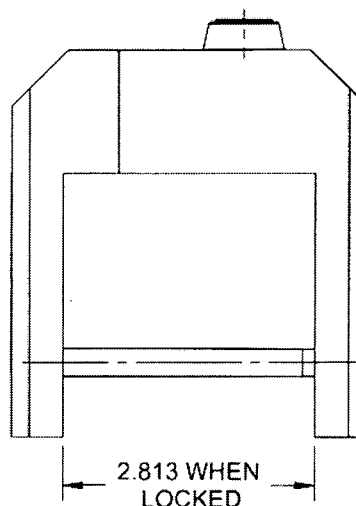


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE	05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**

*W/O
SIZES*



RELEASED
05/04/23

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

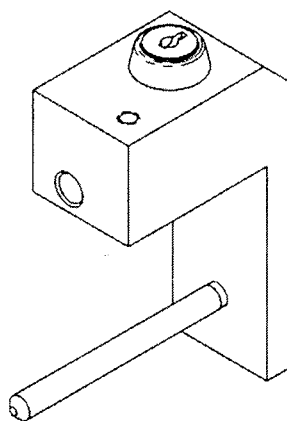
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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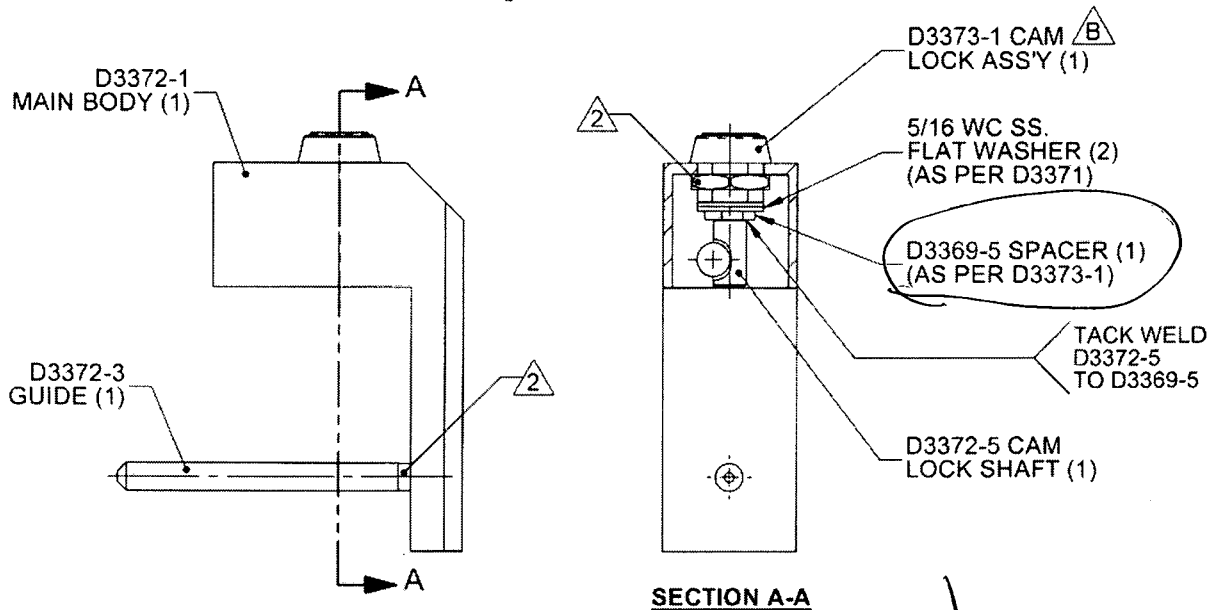
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



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[Signature]
05/04/23



D3372-053 LOCK ASS'Y

NOTES:

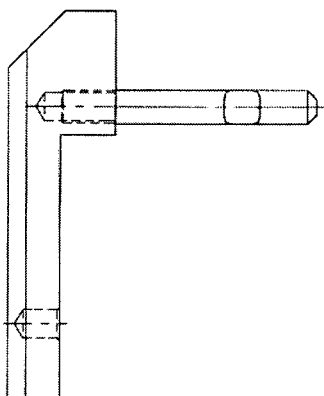
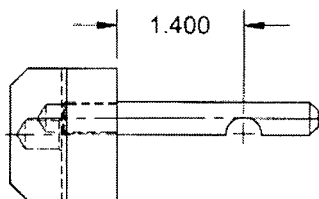
- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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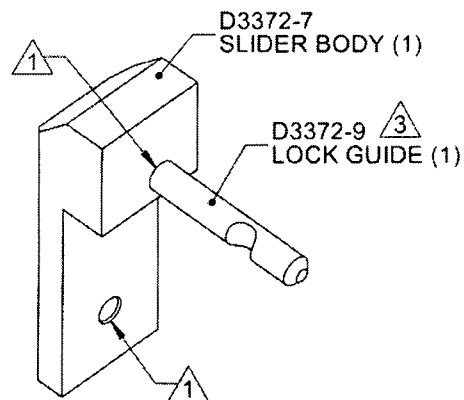
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



RELEASED
[Signature]
05/04/23



[Handwritten signature]

D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

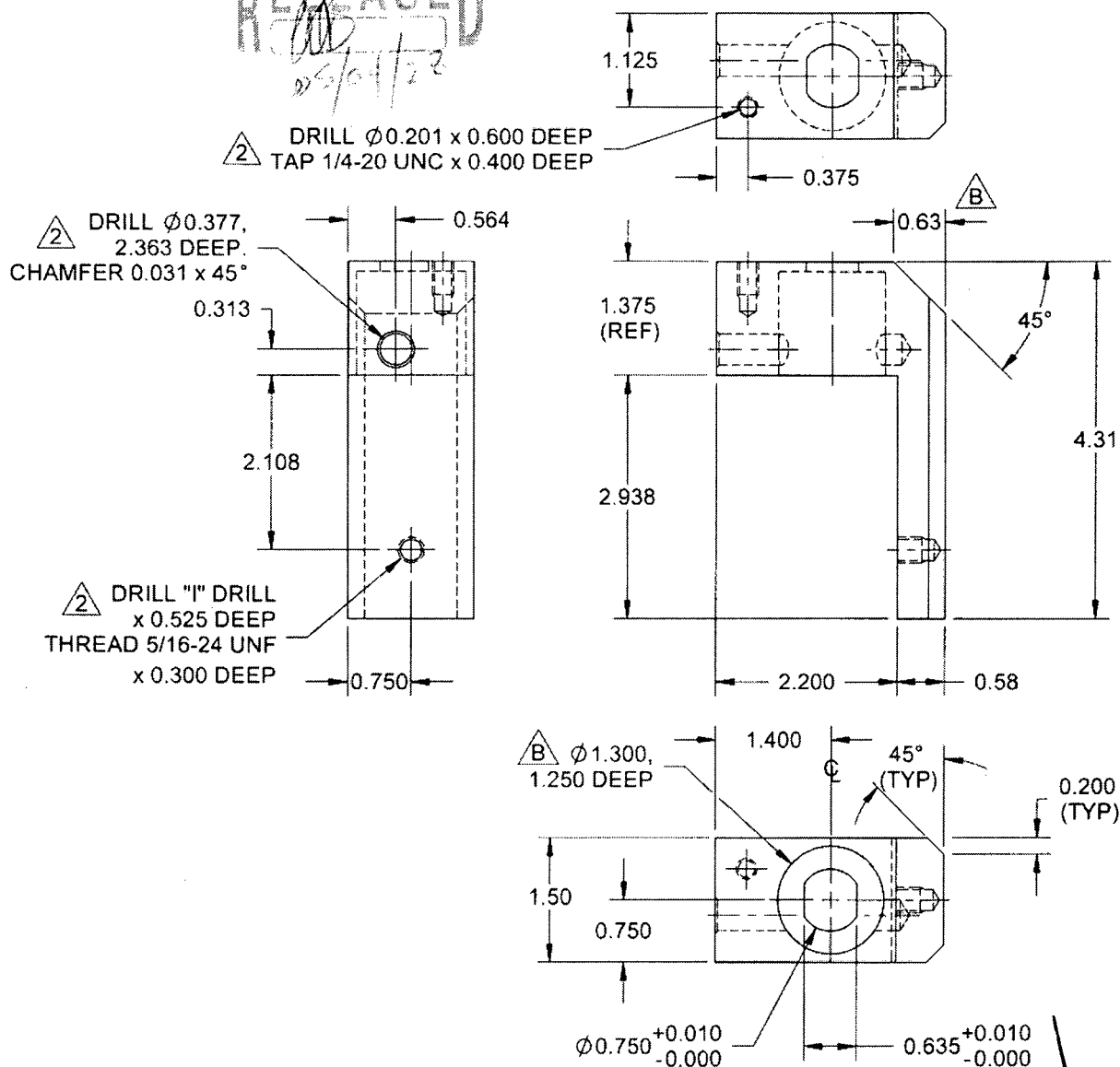
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED
25/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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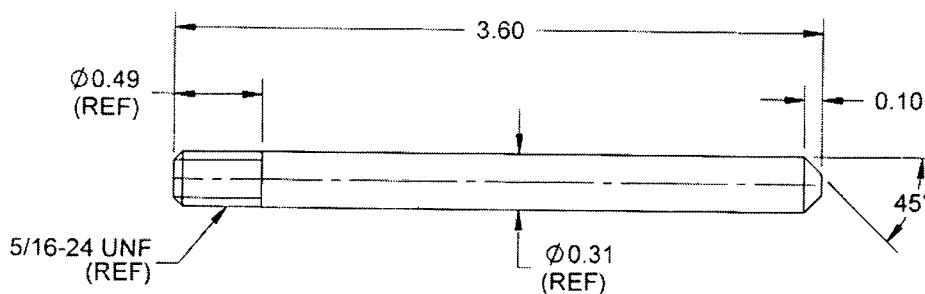
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

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[Signature]
05/04/23



D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

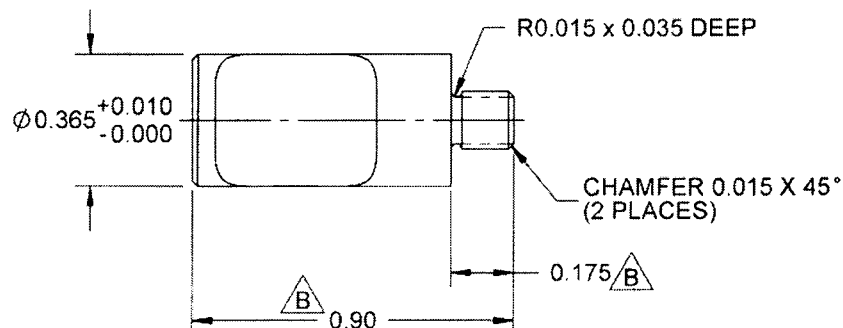
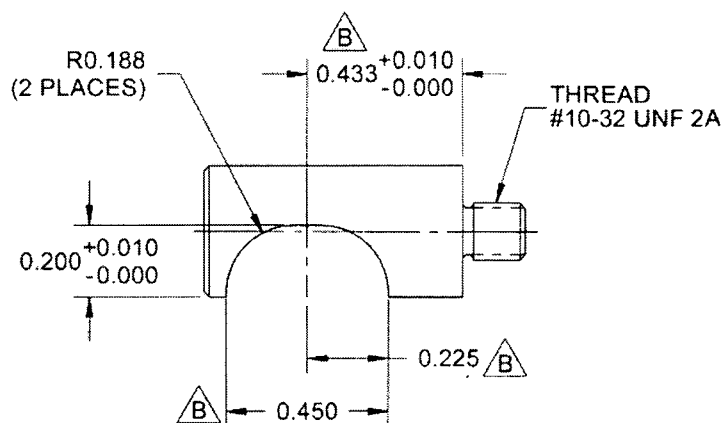
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DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 2:1

RELEASED
[Signature]
05/04/23



alv
5/29

D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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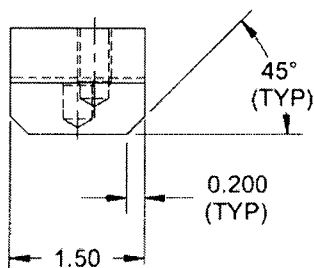
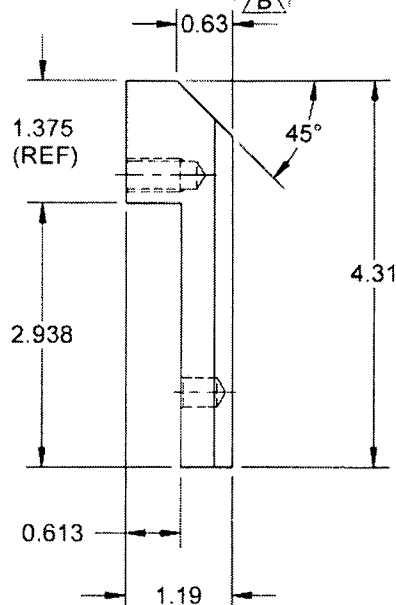
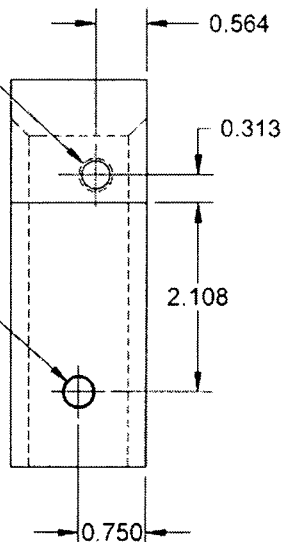
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

DRILL $\phi 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\phi 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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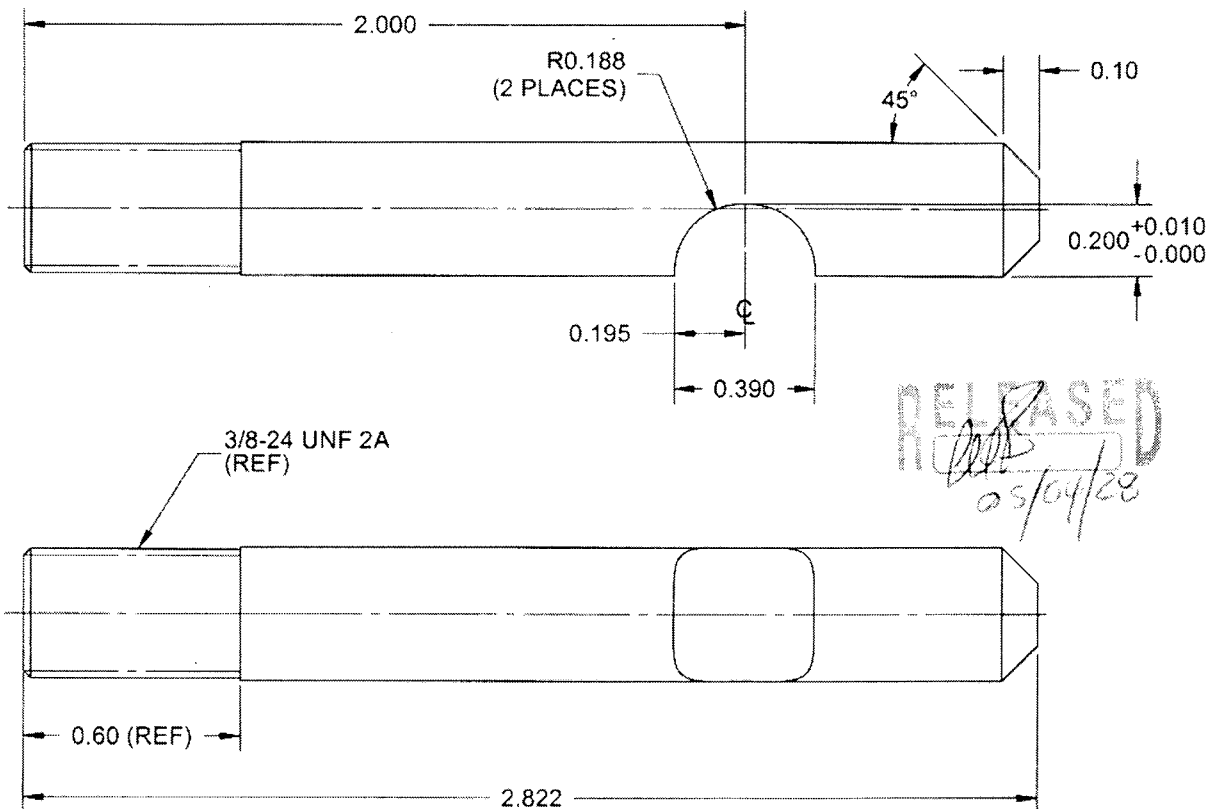
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wlo
5929



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

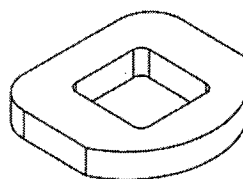
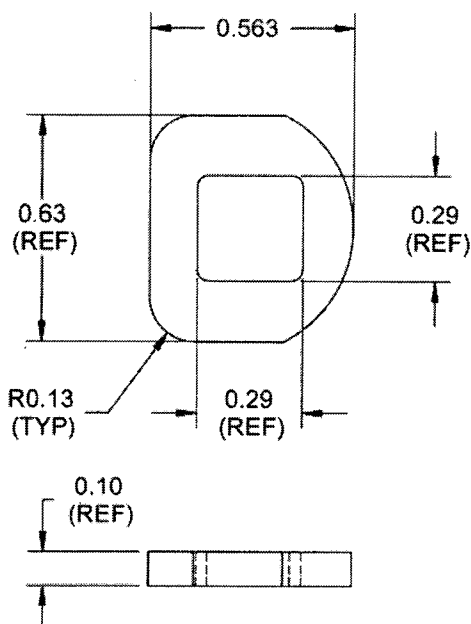
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11

59129

-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries